110 QC

Quality Control

Page 1 January-11-13 8:36:53 AM Item ID: D3889-3 Accept *N900040100* Setup Start Revision ID: Item Name: Gasket *4* Start Date: Start Oty: 4.00 1/11/13 **Cust Item ID:** Required Date: 1/25/13 **Reg'd Oty:** 4.00 *//* **Customer:** Reference: Run Process Plan: MLJ Date: 13-01-11 Tooling: Approvals: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. Work Center ID Description Qty **Run Hours** Code Otv Number Stamp Draw Nbr **Revision Nbr** D3889 Α 100 0.00 *100* B13-1-27 Waterjet 0.00 Memo FLOW CNC Waterjet 1-Cut as per Dwg D3889 Dwg Rev: Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00

0.00

Memo

												DQA:	Dat	e:	
NCR:	Yes	/ No				WORK ORDER NON-C	100	NFORM	/ANCE / UP	PDATE		•			
												QA Closed:	Dat	e:	
Work Ord	or.					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No				Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier			Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Ad	ction		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Desc	cription		Date	Verification	1	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY				 		
Landi		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube			o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	li	Ripples in Bend				Drill Holes	1	Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 2

January-11-13 8:36:53 AM Item ID: D3889-3 Accept *N900040100* Setup Start **Revision ID:** Item Name: Gasket **Start Date:** 1/11/13 Start Otv: 4.00 **Cust Item ID:** Required Date: 1/25/13 **Reg'd Otv:** 4.00 **Customer:** Reference: Start Run Process Plan: Date: Approvals: Tooling: Date: Stop SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Accept Reject Insp. Work Center ID **Description** Run Hours Code Qty Number Stamp **Qty** 120 OC8- Inspect parts - second check *120* Memo Quality Control 130 Identify as per dwg & Stock Location: 0.00 *130* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00 *140* 0.00 Memo Quality Control

MB0139

									DQA:	Date:	
NCR: Y	es / No		•		WORK ORDER NON-C	CONFORI	MANCE / UPDATE		OA Classed	Date	
					[QA Closed:	Date:	
Work Order:					DISPOSITION		DEPARTMENT/PROCESS				
Part No.					Rework Scrap Use-as-is Work Order Update	- 1	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		1		i							
Material											
Setup											
Other											
Process		1									
Supplier											
Training											
Unapproved			1								
				_	F.	AULT CATE	GORY				
Landii	ng Gear				General				_		_
	Bending				Bend	Grain		L	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.	•		Burrs	Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing	Wrong Stock Pulled
	Cuffs			Г	Contamination	Mainte	enance		Part Moved	<u></u>	_
	Heat Treat				Countersink	Mislabe	eleć		Positioned V	Vrong	

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Picklist Print

January-11-13 8:36:57 AM

Work Order ID: 95541

75571

Parent Item: D3889-3

Parent Item Name: Gasket

95541

D3889-3

Start Date: 1/11/13

Required Date: 1/25/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	290.1800	3.3053	13.91705	161		
*M4111NS									**	121, 1, 00	1B13-1	-77	

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Page 1

										DQA:	Date:				
NCR: Ye	es /	No				WORK ORDER NON-C	ONFORM	MANCE / UPI							
										QA Closed:	Date:				
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Work Oraci				Rework	1	Skid-tube Crosstube			Water Jet	Engineering					
Part No.			Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality						
			. · · · · · · · · · · · · · · · · · · ·	Use-as-is Thermoforming Finishing				re/Packaging	Other						
NCR No.			Work Order Update		Large Fab	Composite	,	Supplier							
						· <u> </u>		·							
Root					Descri	ption of work order update	Initial	Action		Sign &					
Cause	D	ate	Step	Qty	(or Non-conformance	Chief Eng	Description		Date	Verification	QC Inspector			
Doc/Data															
Equip/Tooling		-													
Operator		Ì													
Material											,				
Setup						•									
Other			•		İ										
Process		ļ													

FAULT CATEGORY										
Landing	Gear	General								
	Bending	Bend		Grain		Ovalized Pressure/Forced				
	Centre Not Concentric to O/S	BOM/Route		Hardware		Over/Under tolerance Temperature/Cure				
	Cracks	Broken/Damaged		Inspection Incomplete		Part Incorrect Weld				
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear		Part Lost/Missing Wrong Stock Pulled				
	Cuffs	Contamination		Maintenance		Part Moved				
·	Heat Treat	Countersink		Mislabeled		Positioned Wrong				
	Inspection Strip in Tube	Cut Too Short		Misread		Power Loss/Surge Other				
	Ripples in Bend	Drill Holes		Offset						
	Torque Waves in Extrusion	Drawing		Out of Calibration						
	Turning Sequence	Finish		Out of Sequence						
	Wave/Twist in Tube	Folio		Outside Dimensions						

Supplier Training Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95541
Description: Gasket	Part Number:	D3889-3
Inspection Dwg: D3889 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

				1			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
14.0	+/-0.030	14.0	7		T BUI		
34.0	+/-0.100	34.0	2		7		
0.125	+/-0.010	661,	(VIBOZ		
						 	
							- widdings
			<u> </u>	ر ع			
easured by: 🕃		Audited by:	\$9	7 [Prototype Appre	oval:	N/A
Date: 3	1-70	Date:	13-1-20	→		Date:	N/A

Measured by:	Audited by:	89 /	Prototype Approval:	N/A
Date: (3 - (-)	Date:	13-1-28	Date:	N/A

Rev	Date	Change	Revise	Լ by	Approved	
Α	09.07.29	New Issue	KJ 🦠	4	<i>A</i> /\	٦
				, 	130	_

PARTS LIST ITEM DESCRIPTION D3889-041 PANEL FLOOR D3889-1 PANEL D3889-3 GASKET A/R 3M 1300 ADHESIVE 34.0 REF -D3889-1 PANEL -D3889-3 GASKET 8 С St. 2 15.4 R. TUBNIS 34.7 REF ENGLARITH, G UNCONTROLLED COST SUBJECT TO AMENDMES WITEGUT SOTICE WORK ORDER NO 95541 MLJ 13-01-11 TEXTURED SIDE SHOWN-D3889-041 PANEL, FLOOR Α NEW ISSUE CP 09.04.20 NOTES: 1) MATERIAL: N/A 2) FINISH: NONE REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD 2) FINISH: NOINE
3) TOLERANCES: PFR DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3889-041" AND B/N USING FINE POINT PERMANENT INK MARKER
ON SMOOTH/UNTEXTURED SIDE OF PART DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3889 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE 7) WEIGHT: 5.13 Ibs 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE. TRIM GASKET TO EDGES OF PANEL, IF REQUIRED. DE APPR PANEL, FLOOR COPYRIGHT © 2009 BY DART AEROSPACE LTD

PAS DOCUMENT IS PRIVITE WIND CONTROL WIND IS SUPPLED ON THE EMPLES CO-OFTED

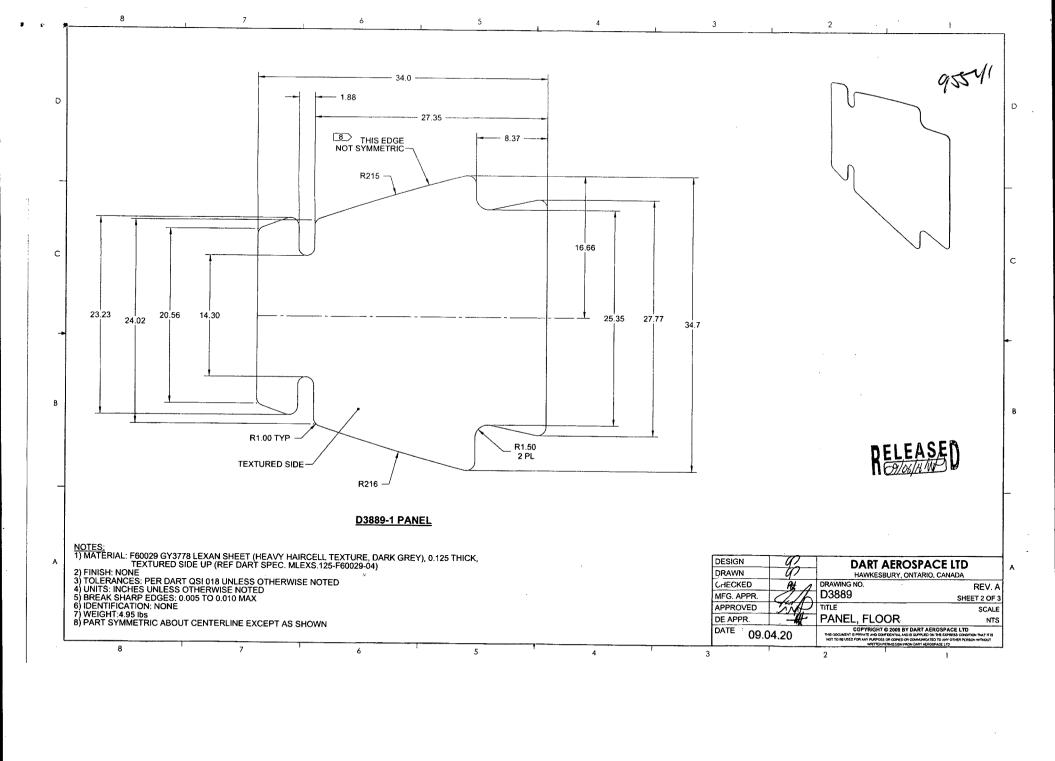
MOTTO BE USED FOR MY PARFOLD ON COMED OR COMMENCED TO JOHN OTHER PRICOR

WHITTENED SECOND ON THE DARF AEROSPACE LTD

WHITTENED SECOND ON THE DARF AEROSPACE LTD

WHITTENED SECOND ON THE DARF AEROSPACE LTD DATE 09.04.20 8 2

D



3 D 14.0 C **D3889-3 GASKET** NOTES:
1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK (REF DART SPEC. M4111N-S.125)
2) FINISH: NONE
3) TOLERANCES: PER DART GSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: NONE
7) WEIGHT: 0.19 lbs DESIGN **DART AEROSPACE LTD** DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D3889 MFG. APPR. SHEET 3 OF 3 APPROVED TITLE SCALE PANEL, FLOOR DE APPR. NTS TAINLE, I LOUIN

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